Date

Tuesday, 11/21/2006 1:15:25 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 29603

Estimate Number

: 10993

P.O. Number

:NA

This Issue

Previous Run

: 11/21/2006

: NC

Prsht Rev. First Issue

: NA : 29489

S.O. No. : NA

Type

: MACHINED PARTS

Part Number Drawing Number

Drawing Name

: D2579 REV D : N/A

Project Number **Drawing Revision**

: D2579

Material **Due Date**

: 12/5/2006

: CROSSBOLT SPACER

Qty:

600 Um: Each

Written By

Checked & Approved By

Comment

: Est E

Now turned on Cobra NG

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M6061T6T0500W058 1.0

6061-T6 Tube .500 x.058W

Comment: Qty.:

0.3762 f(s)/Unit Total: 225.7290 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4) Batch 102 765

0.500 Dia x 0.058 Wall

HARDINGE CNC LATHE SMALL

2.0

HARDINGE

Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA245

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

1/4/4/28



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1

600 26.11.28

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

BARCUY

Dart Aerospace Ltd

	. oopaoo								
W/O:			WC	ORK ORDER CHANG	SES		* *		
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	Nø DQA		} Date: ∠	ydu (30
								Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORM	ANCE (NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Action Description		Sign &	Verification Section C		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date				,
		·					ı		
				,					

NOTE: Date & initial all entries

Date:

Tuesday, 11/21/2006 1:15:25 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 29603

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description:

QC21

FINAL INSPECTION/W/O RELEASE







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



(206/11/30

Dart Aerospace Ltd

Dait Ac	ospace	Ltu								
W/O:			WC	RK ORDER CHANG	GES					
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										
			•							
Part No	:	PAR #:	PAR #: Pault Category: NO					CR: Yes No DQA: Date: QA: N/C Closed: Date:		
NCR:			WORK ORDI	R NON-CONFORM						, <u>, , , , , , , , , , , , , , , , , , </u>
DATE	STEP	STEP Description of NC Section A	Corrective Action Section B				Verification		Approval	Approval
DATE			Initial Chief Eng	Action Description Chief Eng	S	ign & Date			Chief Eng	QC Inspector
•					,					
				<u> </u>						
	-						:			
	ł		}				1			1

NOTE: Date & initial all entries

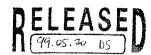
DART AEROSPACE LTD	Work Order:	29603		
Description: Cross Bolt Spacer	Part Number:	D2579		
Inspection Dwg: D2579 Rev: D		Page 1 of 1		

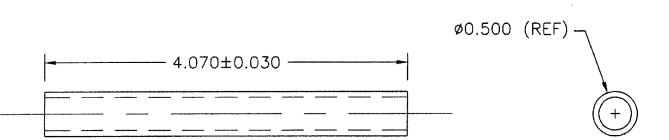
FIRST ARTICLE INSPECTION CHECKLIST							
X First Article Prototype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Coi	nments
4.070	+/-0.030	4,082	1				
0.058	+/-0.010	1054	/				
			-				
11.11.7.4.0							
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							• • •
Measured by:) # 1	Audited by:	J.L	Р	rototype App	roval:	N/A
Date:	6/11/27	Date:	06/11/2	7		Date:	HIM
Rev Date	Change				R	evised by	Approved





			The second secon						
	DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
١.	CHECKED	APPROYED	DRAWING NO. REV. D						
)	#	HE	D2579 SHEET 1 OF 1						
	DATE	V	TITLE SCALE						
	99.05.19		CROSS BOLT SPACER 1:1						
	A.	96.09.16	NEW ISSUE						
	В	96.12.05	0.065 WALL WAS 0.035 WALL						
	С	97.02.21	0.058 WALL WAS 0.065 WALL						
	D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)						





MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4) SHOP COPY 0.500 DIA x 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED IN THE PROPERTY OF THE

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WORK ORDER NO. 29603